Work Orde April-04-14 10:	er ID 1155 13:27 AM	68		*11	5568*						Page 1
Revision ID:	D3489-3-200 Pip Pin			Accept	*N900	040	100)* s	etup Star	·· [\(\frac{1}{4} \)	S1* S2*
Start Date: Required Date: Reference:		Start Qty: 10.00 Req'd Qty: 10.00	1 ()		Cust Item 1 Customer:	D:					
Approvals:	Process Plan:	MLS	Date: 14-04-04	Tooling:	D	ate:		R	dun Star	<i>-</i> 3171	R1*
	QC:		Date:	SPC (Y/N):	D	ate:			Sto	*N	R2*
Sequence ID/ Work Center II		peration escription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revisio	on Nbr									
D3489	Rev A										
1 nn Purchasing Purchasing	PU	URCHASING Memo Issue P/O:,	23799 <u> </u>	0.00 0.00 Possible Supplier: Jo	ergens			X	14/0	<u>4/14</u>	10
110 *110* Packaging	Re	eceive & Inspect for I	Damage & Mat'l Certs	0.00			·	Yal) 4 4 10		-
Packaging			terial certification is attached						, ,		
120 *1 2 0 * QC	Qı	C6- Inspect dimensio Memo	ns to drawing	0.00 P				10			
Quality Control											

DQA:	Date:												•	TO AC
						WORK ORDER NON-	-CC	ONFO	RMANCE / U					AEROSPACE
QA Closed:			Date:							\	Nork Order ι	pdate only		·
Work Orde	er:					DISPOSITION				AGAINST (DEPARTMEN	T/PROCESS		
	•			· · · · · · · · · · · · · · · · · · ·		Rework			Skid-tube Crosstube			Water Jet	П	Engineering
Part N	No.					Scrap		Machining Small Fab			Prod. Eng. Coor. Quality			
	•					Use-as-is		Thern	noforming	Finishing	_	re/Packaging	П	Other
NCR No.				Suspected Unapproved			Large Fab	Composite		Supplier				
Root					Desci	ription of work order update	1	Initial	Ac	tion	Sign &			·
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verificatio	n	QC Inspector
Design										•				
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material						!								
Operator														
Offset/Setup														
Process					j								ł	
Supplier														
Training					1									
Transport							1						1	
Unapproved			<u> </u>	<u></u>								1		,
							FA	ULT CA	TEGORY					
Landi		1			_	General		1		r			$\overline{}$	
	\square	Bending			<u> </u>	Bend		1	rogram	1	Outside Dir		Н	Pressure/Forced
	Ш	Centre No	ot Conce	ntric	<u> </u>	BOM/Route		Grain			Over/Unde			Set-up
	\vdash	Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		_	Part Incorr		\vdash	Temperature/Cure
		Crimp/Kir	nk/Ripple	e/Wave	\perp	Burrs	<u> </u>	1 '	ion Incomplete/U	· -	Part Lost/N	_	-	Weld
	Н	Cuffs				Contamination		4	tions Incomplete/	+	Part Move		Ш	Wrong Stock Pulled
	-	Crushing				Countersink	<u> </u>	4	ned/off center	1	Positioned	_		
	\vdash	Heat Trea			_	Cut Too Short	\vdash	Mislabe		Ł	Power Loss	/Surge		Other
	Inspection Strip in Tube			Drawing	\vdash	Misrea								
	\vdash	Marks/Ch				Drill Holes		Off-set						
	Turning Sequence			Finish	<u></u>	-{	Calibration							
	Wave/Twist in Tube				Fit/Function	1	Out of	Sequence						

Work Orde April-04-14 10:		5568		*115	Page 2				
Item ID: Revision ID:	D3489-3-200			Accept	*N90004	40100)* Setu	p Start	17.71
Item Name:	Pip Pin							Stop	*NS2*
Start Date:	4/04/14	Start Qty: 10.00	*10*		Cust Item ID:				
Required Date:	4/04/14	Req'd Qty: 10.00	*10*		Customer:				
Reference:								.	
Approvals:	Process Plan	n;	Date:	Tooling:	Date:		Run		^IVH I ^
	QC:		Date:	SPC (Y/N):	Date:			Stop	*NR2*
Sequence ID/ Work Center II	D	Operation Description Identify as per dwg & Sto	ck Location: GA	Set Up/ Run Hours	Tool ID To	ool # Plan Code		Reject Įty	Reject Insp. Number Stamp
120 Packaging		Мето		0.00			_10X	DAS 28 9-89	APR 1 6 2014
Packaging									
140		QC21- Final Inspection -	Work Order Release	0.00				•	
140		Memo		0.00				PC 14	1-4-17
Quality Control						(114	04-	-16

\$2. a 3

DQA: Date:									_					•	
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / L	JPDATE	Wo	ork Order up	odate only		AEROSPACE
Work Orde) r·					DISPOSITION				AGAINST		PARTMENT	· · · · · · · · · · · · · · · · · · ·		
Part No.			<u> </u>	Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing				Water Jet Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other		
NCR No.				Suspected Unapproved				Composite			Supplier	-			
Root					Desc	ription of work order update	ı	Initial		tion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Design Doc/Data	\dashv														
														- 1	
Equip/Tooling Handling/Pre							1						į		
Material															
Operator															
Offset/Setup	\dashv														
Process	\dashv														
Supplier	\dashv														
Training				İ											
Transport															
Unapproved															
				<u> </u>	1	- -	FA	ULT CA	TEGORY			l			
Landi	ng G	ear				General		, .							
		Bending				Bend	Г	Folio/P	rogram		Г	Outside Dim	ensions		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	\vdash	Grain	· ·			Over/Under	tolerance	-	Set-up
		Cracks				Broken/Damage/Defect	Г	Hardwa	ire			Part Incorred	ci	-	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/L	Inqualified		Part Lost/Mi	ssing	-	Weld
		Cuffs				Contamination		1	ions Incomplete/	-		Part Moved	-	П	Wrong Stock Pulled
		Crushing				Countersink		-1	ned/off center			Positioned V			
		Heat Trea	it			Cut Too Short		Mislabe				Power Loss/	-	\Box	Other
		Inspectio	n Strip in	Tube		Drawing		Misread	d		_	•	•		
		Marks/Ch	natter			Drill Holes	Г	Off-set							
		Turning S	equence			Finish		Out of (Calibration						
Wave/Twist in Tube			Fit/Function	Г	Out of	Sentience									

April-04-14 10:13:27 AM

Work Order ID: 115568

Parent Item:

D3489-3-200

115568 *D3489-3-200*

Parent Item Name: Pip Pin

Start Date: 4/04/14

Required Date: 4/04/14

Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
806206		Purchased	No			100	Each	0.0000	1	10	1		
806206									**		La Cely	M	(CS_

PIP PIN

DQA:		. Date:	4 37/4/19/11											
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / U	PDATE	W	ork Order up	odate only	7	AEROSPACE
Work Orde	P		-		DISPOSITION			**************************************	AGAINST		PARTMENT,	·		
Part N					Rework Scrap		Skid-tube Crosstube Machining Small Fab				Water Jet Prod. Eng. Coor.			Engineering Quality
NCR No.				Use-as-is Suspected Unapproved		Thermoforming Finishing Large Fab Composite							Other	
Root	l'			Desci	ription of work order update		Initial	Act	ion		Sign &		Т	
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification		QC Inspector
Design Doc/Data	_													
quip/Tooling	-													
landling/Pre	7	ĺ												
Material -	7			ļ									ı	
perator														
Offset/Setup														
rocess														
upplier	7	•												
raining														
ransport	7													
Jnapproved														
						FA	ULT CAT	EGORY						
Landin	g Gear				General		_							
	Bending				Bend		Folio/P	rogram			Outside Dim	ensions	P	Pressure/Forced
	Centre No	ot Concei	ntric		BOM/Route		Grain				Over/Under	tolerance	s	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorrec	:i		emperature/Cure
	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Ur	nqualified		Part Lost/Mis	ssing	_ ^	Veld
1	Cuffs				Contamination	_	1	ions Incomplete/l	Jnclear	_	Part Moved	L		Wrong Stock Pulled
ļ	Crushing				Countersink	_	4	ned/off center		-	Positioned W		_	
Heat Treat			<u> </u>	Cut Too Short		Mislabe				Power Loss/S	Surge	<u> </u> 0	Other	
	Inspection	•	Tube	\vdash	Drawing	_	Misread	l						
-	Marks/Ch			<u> </u>	Drill Holes		Off-set							
-	Turning S				Finish		4	Calibration						
	Wave/Twist in Tube				Fit/Function	Out of Sequence						,		



	DESIG	CP	DRAWN BY		RT AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
Г	CHECK	(ED //)	APPROVED (1)	DRAWING NO.	REV. A
		Щ	- H	D3489	SHEET 1 OF 1
Г	DATE		4 Y .	TITLE	SCALE
L	06.0	1.04		PIP PIN	NTS
	Α		06.01.04	NEW ISSU	E



SPECIFICATION CONTROL DRAWING

SPECIFICATION: D3489-X-YYY PIP PIN

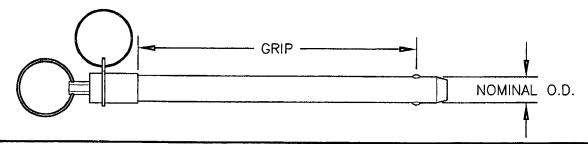
WHERE 'X' IS THE NOMINAL SIZE IN 1/16THS OF AN INCH AND 'YYY' IS THE GRIP LENGTH IN TENTHS OF INCHES

FOR EXAMPLE, D3489-3-050 IS 3/16" NOMINAL O.D. WITH 0.50" GRIP

2) ACCEPTABLE SUPPLIERS / PART NUMBERS TO PURCHASE

DART	Nominal	GRIP	Possible	Suppliers
P/N	O.D.	ĺ	JERGENS	REID
D3489-3-050	3/16"	0.50	806200	DARS-000D
D3489-3-075	3/16"	0.75	806201	-
D3489-3-100	3/16"	1.00	806202	DARS-001
D3489-3-125	3/16"	1.25	806203	-
D3489-3-150	3/16"	1.50	806204	-
D3489-3-175	3/16"	1.75	806205	-
D3489-3-200	3/16"	2.00	806206	DARS-004
D3489-3-250	3/16"	2.50	806208	DARS-005
D3489-3-300	3/16"	3.00	806209	-
D3489-4-050	1/4"	0.50	806216	DARS-009
D3489-4-075	1/4"	0.75	806217	-
D3489-4-100	1/4"	1.00	806218	•
D3489-4-125	1/4"	1.25	806219	-
D3489-4-150	1/4"	1.50	806220	DARS-020
D3489-4-175	1/4"	1.75	806221	-
D3489-4-200	1/4"	2.00	806222	DARS-030
D3489-4-250	1/4"	2.50	806224	DARS-035
D3489-4-300	1/4"	3.00	806225	DARS-040
D3489-4-400	1/4"	4.00	808227	DARS-050

- 3) DESCRIPTION: DOUBLE ACTING, STAINLESS STEEL, QUICK-RELEASE BALL LOCK PINS WITH RING HANDLE
- 4) MATERIAL: STAINLESS STEEL. MIN. PULL OUT STRENGTH = 200LBS (3/16" PINS) OR 230LBS (1/4" PINS). MIN. DOUBLE SHEAR = 5150LBS (3/16" PINS) OR 9200LBS (1/4" PINS).
- 5) ALL DIMENSIONS ARE IN INCHES



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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Tel: 613 632 9577

Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23799

Purchase Order Date 4/14/2014 PO Print Date 4/14/2014

Page Number 1 of 7

Order From:

HASKINS INDUSTRIAL 5-52 ANTARES DRIVE NEPEAN, ON K2E 7Z1 CA VC-HAS001

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

3

Contact Name

Vendor Phone

Ship To Contact

613 723 8800

Dicom

Buyer

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Ship To Phone Ship Via:

Ship Acct:

Line Nbr		Description/ Mfg ID	Req Date/ CD Taxable Promise Date	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	806206 AS PER DWG D 3489 REV. A B115568	PIP PIN	4/21/2014 Yes 4/21/2014	10.00 Each	\$22.85	\$228.50
-					Line Total:	\$228.50
2	71401-45	PROCUREMENT QUALITY CLAUSES	4/21/2014 No	1.00	\$0.00	\$0.00
	PROCUREMENT QUALITY CL A005 RIGHT OF ENTRY A016 PERSONNEL QUALIFICA		4/21/2014			

Line Total:

\$0.00

Note:

A025 CERTIFICATE OF CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS HASKINS INDUSTRIAL INC. 5-52 ANTARES DRIVE

** PACKING SLIP **

Order # 1253223.00

Order Date 04/14/14

Page 2 of

* Reprint

NEPEAN, ONTARIO K2E 7Z1

TEL (613)723-8800 FAX (613)723-8806

Sold To: DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY

ON

K6A 1K7

Ship To: DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY

on

K6A 1K7

		Alway to the	•	40°	e de la companya de La companya de la co			
	Cust P	hone #		Warehouse OTTAWA		.O.B. EST		Taken By Sylvie 613-723-880
Cust # 05168	Customer P/0 23799	#		Required 04/15/14	Orig Order 1253223.00	PL	Ship Via	Terms NET 30
Ln# Bih #	Order UM	Ship	-	Product	De	scripti	lon	
10	5 EA	5		PTD1X1 0047859	901	3.3MM	DRILL	
11	5 EA	0	5	PTD1X1 0047996	901	4.7MM	DRILL	
12	50 C	. O	50	SP1X100	НХ-	26 1/2-	-13X1	SKT C/S
13	50 C	0	50	SP1X100	HX-	10 8-32	2 X 1"	SKT C/S
14	50 C	0	50	SP1X100	HC-	15 1/4	-20X1-3/4	HEX HD C/S
15	50 C	0	50	SP1X100	HX-	211 10	-24X1/2	FH SCREW
16 OLD # F	50 C HN-2033	0	50	SP1X100	179	-W05-11	М 3/8-16	SS LOCKNUT
17	3 EA	0	3	KEO1X1 3870444	IAA	E0125J	3D K600	CARB EM
18 *	2 EA	2 /		SO1X1	124	-140 5,	/16-18	SPRL POINT TAP RED
19 030220	10 EA	10 /		JG-806206	3/1	6 DBL	ACTION RIN	G HANDLE 806200

PLEASE NOTE:

- 1. NO RETURNS WITHOUT PRIOR AUTHORIZATION
- 2. ALL SHORTAGE CLAIMS MUST BE WITHIN 10 DAYS
- 3. BO CODE: BO = QTY NOT SHIPPED IS BACK-ORDERED

CL= QTY NOT SHIPPED WAS CANCELLED

SC= ITEM CONSIDERED COMPLETE - NO B/O CREATED

Printed on 2014-04-15